

Date: Tuesday, 3/11/2008 7:53:51 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	BELL CRANK		
Job Number	37727					
Estimate Number	11967					
P.O. Number	:		Part Number	:	D2056	
This Issue	: 3/11/2008	S.O. No. :	Drawing Number	:	D2056 REV B2	
Prsht Rev.	: NC		Project Number	:	N/A	
First Issue	: / /	Type : MACHINED PARTS	Drawing Revision	:	B2	
Previous Run	: 37629		Material	:		
Written By	:		Due Date	:	3/29/2008	Qty: 12 Um: Each
Checked & Approved By						
Comment	Est. E	02.04.04	Added Rev.B2 NG			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25"	
		Comment: Qty.: 0.2494 f(s)/Unit Total : 2.9925 f(s) 6061-T6 Bar 1.25 x 1.25" Material: 6061-T6, 1.250" x 1.250"	Batch:
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks 2.80" long	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2056 Tumble Deburr any rough edges after tumbling	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BELL CRANK
Job Number: 37727		Part Number: D2056
Job Number:		
Seq. #:	Machine Or Operation:	Description :
7.0	POWDER COATING	POWDER COATING  M 100700  (12X)
Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3		m-l 08/03/26
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		08-02-26 X13
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 570		10/08/27 (12)
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		10/08/27 (12)
Job Completion		 mf 08-03-27 (12) W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

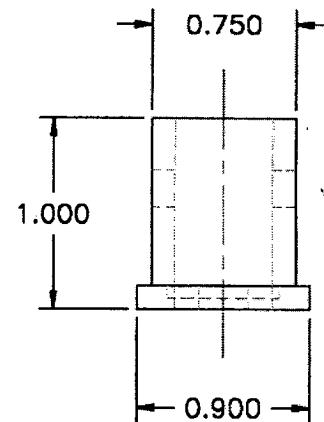
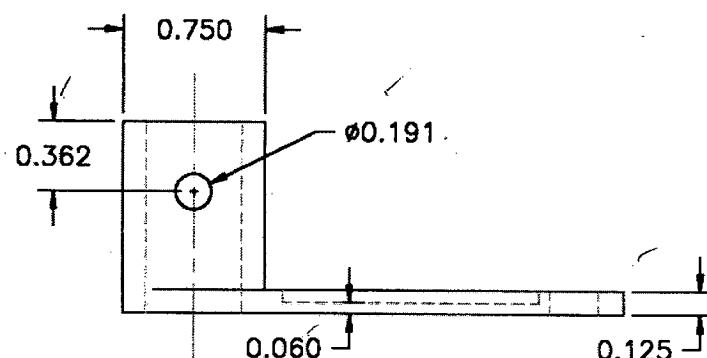
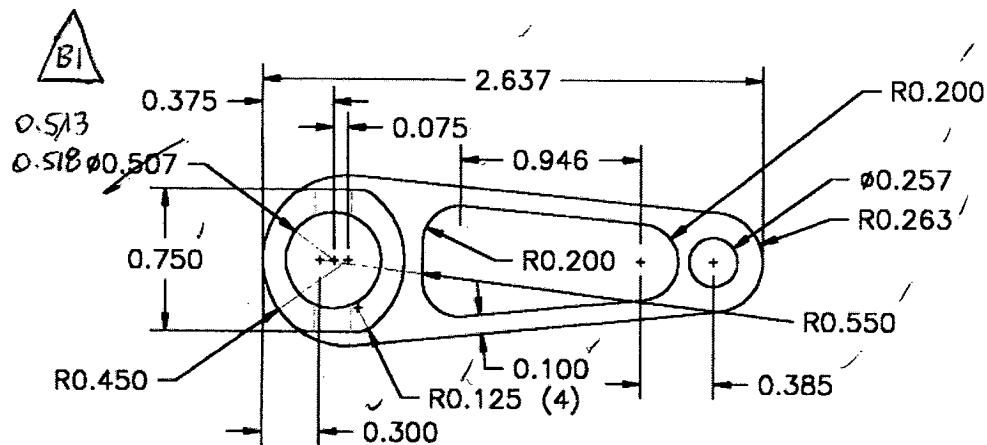
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART****RELEASED**  
*(94 04 28 HE)*

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
B WILLIAMS	K HAND		
CHECKED <i>(Bm)</i>	APPROVED <i>KE</i>	DRAWING NO. D2056	
DATE 92:03:13	TIME 01.00.04	MATERIAL BELL CRANK	SCALE 1:1



**(B1)** ACID ETCH & ALODINE PER  
DART QSI OOS 4.1  
POWDER COAT BLACK STANDARD  
(4.3.5.7) PER DART  
QSI OOS 4.3

MATERIAL: 6061-T6 (QQ-A-225/8)  
FINISH: ANODIZE (BLACK) OR  
TOLERANCES ARE PER DART QSI OOS UNLESS OTHERWISE NOTED.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 3727

DART AEROSPACE LTD	Work Order:	37727
Description: bell crank	Part Number:	D 2056
Inspection Dwg: D 2056 Rev: B2		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

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## **First Article**

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# Prototype

Measured by:	J.L.
Date:	08/03/18

Audited by:	26
Date:	08/03/18

<b>Prototype Approval:</b>	
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

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